

Derw 63147

Work Order ID 52586



October 2, 2009 11:22:26 AM

Item ID: D2932-2

Accept



Setup Start



Revision ID: C

Stop



Item Name: Saddle RH Out, 206

Start Date: 02/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 14/10/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: BS

Date: 09-10-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2932	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
	Memo	0.00							
	HAAS CNC vertical machine #1								
	Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv								
	Memo	0.00							
	Conventional Milling Machine								
	Machine Keyway and inspect per attached dimension sheet								
120	QC1- Inspect dimensions to dimension sheet	0.00							
	QC								
	Memo	0.00							
	Quality Control								

mmf/SL 09/11/19

SL 09/11/25

mmf/SL 09/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 02932-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: / Date: 10-10-21  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>52586</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-11-18	100	Operator made another pass on the saddle bore, & went in the wrong direction with the offset & now the bore is larger. R.C: Lora.	<u>/</u> 05/11/18	Scrap & replace. <u>BUCKHO</u>	<u>mm</u> 09/11/19	<u>SP</u> 09/11/19	<u>/</u> 05/11/18	<u>/</u> 05/11/18



NOTE: Date & initial all entries




# Work Order ID 52586

October 2, 2009 11:22:26 AM

Page 2

Item ID:	D2932-2	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Saddle RH Out, 206					
Start Date:	02/10/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	14/10/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	BB 09/11/19			6	1		HO
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	JL 09/11/20			X6	Ø		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M11214B Memo START TIME: 9:10 AM 8:40 AM FINISH TIME: 3:09 PM	0.00  0.00	JL 09/11/20			X6	Ø		

M115291

START: 8:50  
OVENT: 320°  
FINISH: 4:20

10-10-19.

6.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2932-2 / B 82586 PAR #: \_\_\_\_\_ Fault Category: inspection / QC NCR: Yes No DQA: \_\_\_\_\_ Date: 10/10/21  
 Resolution: rework Disposition: rework QA: N/C Closed Date: 10/10/21

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/11/23	#130	Found during PL that a saddle had a note on it that the slot was missing. In further investigating it	<i>[Signature]</i>	- Machine key way + Debur. - Remove PL. - Re Aluma per ASTM	<i>[Signature]</i> 09/11/23 10/10/18	<i>[Signature]</i> 10/10/21	<i>[Signature]</i>	<i>[Signature]</i> 09/11/23
↓	↓	was found that all saddles had no slot/key way for the skid tube. PL missed at inspection. Called no Dims on FAI sheet.) L O A	<i>[Signature]</i> 10/10/18	- Re PL dte + 6 saddles. → issue as ncr	<i>[Signature]</i> 09/11/25 10/10/18	<i>[Signature]</i> 10/10/21	<i>[Signature]</i> 10/10/18	<i>[Signature]</i> 09/11/23
10/10/18	100	Qty (3) saddles, thickness of keyway is 0.233 (dws = 0.235 min)	<i>[Signature]</i> 10/10/18	Acceptable. SR-D206-642 Rev. B, margin of safety = 1.19, i.e. sufficient margin	<i>[Signature]</i> 10/10/21	<i>[Signature]</i> 10/10/21	<i>[Signature]</i> 10/10/18	<i>[Signature]</i> 09/11/23

NOTE: Date & initial all entries




October 2, 2009 11:22:26 AM

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[illegible]

**Required Date:** 14/10/2009

**Required Qty: 6.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003RevB		Manufactured	No			100	Each	0.0000	6.0000			
												
Saddle Billet, 7075												

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 52586
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.121	.121	.121		
B	0.100	0.140		.126	.121	.120	.121		
C	0.100	0.140		.123	.120	.119	.119		
D	0.210	0.230		.225	.219	.219	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512	8F	
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.237	.237	.237	8F	
N	0.100	0.140		.109	.111	.111	.112		
O	0.540	0.560		.546	.547	.547	.547		
P	0.490	0.510		.499	.502	.501	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.255	.248	.247	.247		
T	0.100	0.180		.130	.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.134	1.138	1.138	1.138		
Y	1.565	1.585		1.572	1.575	1.577	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: / SL	Audited by: 8F
Date: 09/11/19	Date: 09/11/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52586
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

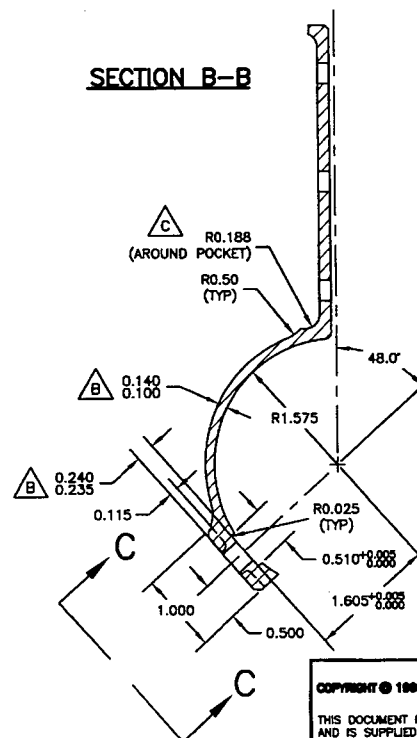
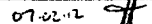
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		.122	.123				
B	0.100	0.140		.121	.122				
C	0.100	0.140		.119	.121				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.512	.512			RF	
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.236	.237			RF	
N	0.100	0.140		.112	.111				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.501	.501				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.245	.249				
T	0.100	0.180		.130	.130				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.137	1.136				
Y	1.565	1.585		1.577	1.572				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									


Measured by: SL	Audited by: RF
Date: 09/11/19	Date: 07/11/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



NO. 52584  
BP 09-10-2



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b> BELLINGHAM, WA
CHECKED	APPROVED	
DATE	TITLE	REV.
06.11.09	SADDLE OUTSIDE	SHEET 1 OF 2

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